

# Work Order ID 56533

March 1, 2010 9:42:13 AM



Page 1

Item ID: D3564-13

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 3/01/10 Start Qty: 12.00



Cust Item ID:

Required Date: 3/08/10 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

*U*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3564

Rev D

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3564 ☐ Dwg Rev: D ☐ Prog Rev: D ☐ 2-  
Debur if necessary

*304.063*

*10-3-9*

*18*

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*10-3-9*

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

*8/03/09*

*(18)*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 56533

March 1, 2010 9:42:13 AM



Page 2

Item ID: D3564-13

Revision ID:

Item Name: Wearshoe

Start Date: 3/01/10 Start Qty: 12.00

Required Date: 3/08/10 Req'd Qty: 12.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Brake NC

Brake NC

NC BRAKE

0.00

Memo

0.00

Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT 8179

88 10/03/17

18

8

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

5 10/03/17

410

150



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

0.00

START TIME: 8:15AM FINISH TIME: 8:45AM OVEN TEMPERATURE: 370F

=> 10/03/17

210 9



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 56533**

March 1, 2010 9:42:14 AM



Page 3

Item ID: D3564-13

Revision ID:

Item Name: Wearshoe

Start Date: 3/01/10 Start Qty: 12.00

Required Date: 3/08/10 Req'd Qty: 12.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

BR 10-3-22

(10)

A.

Memo

0.00

170



Packaging

Packaging

Identify as per dwg &amp; Stock Location:

FP-17

0.00

BR 10-3-22

(10) &amp;

Memo

0.00

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/03/23

mr

10-3-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

March 1, 2010 9:42:12 AM

Page 1

Work Order ID: 56533

Parent Item: D3564-13

Parent Item Name: Wearshoe

Comments: IPP Rev:A New Issue 07-03-08 ec  
 IPP Rev:B As per Rev C 07-07-09 JLM  
 IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC  
 IPP Rev:D Comments revised on Step 5, 6 per B44657 09-02-04 KJ

Start Date: 3/01/10

Required Date: 3/08/10

Start Qty: 12.00

Required Qty: 12.00

M304S16GA

Purchased No

100 sf

179.8899 2.8042

4.5

B 10-3-9



304/316 Sheet .063



## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT

179.8898737

106860

8.0295

111924

25.1689737

112442

29.8865

113295

116.8049

18

113295

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

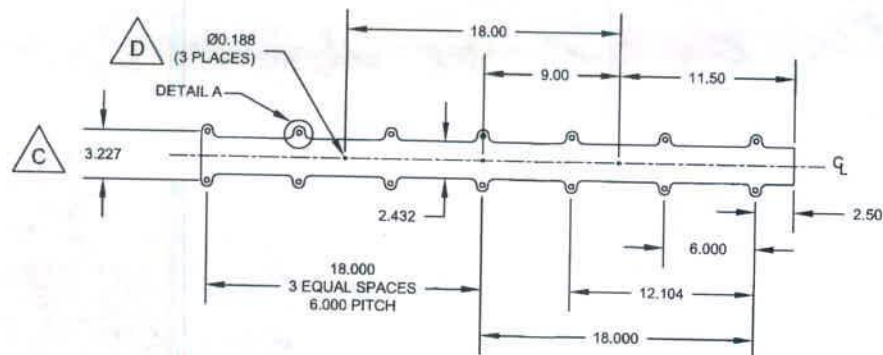
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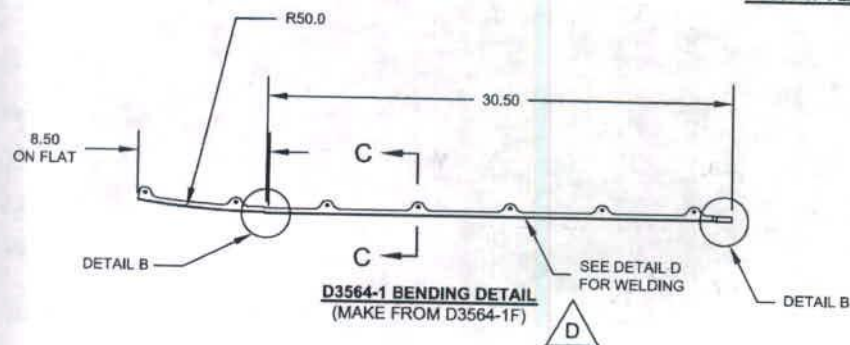
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

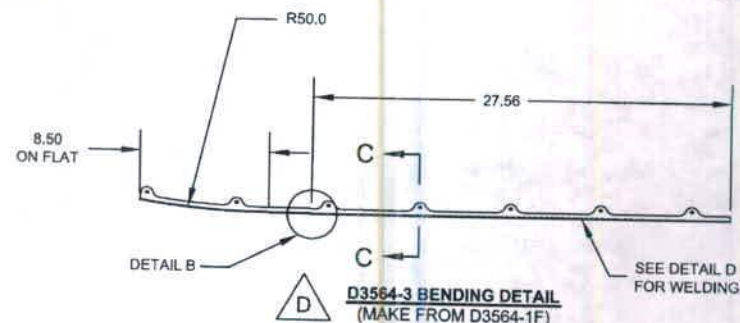




**D3564-1F FLAT PATTERN**



**D3564-1 BENDING DETAIL**  
(MAKE FROM D3564-1F)



**D3564-3 BENDING DETAIL**  
(MAKE FROM D3564-1F)

**D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT  $\bar{C}$

**WEIGHTS:**

D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

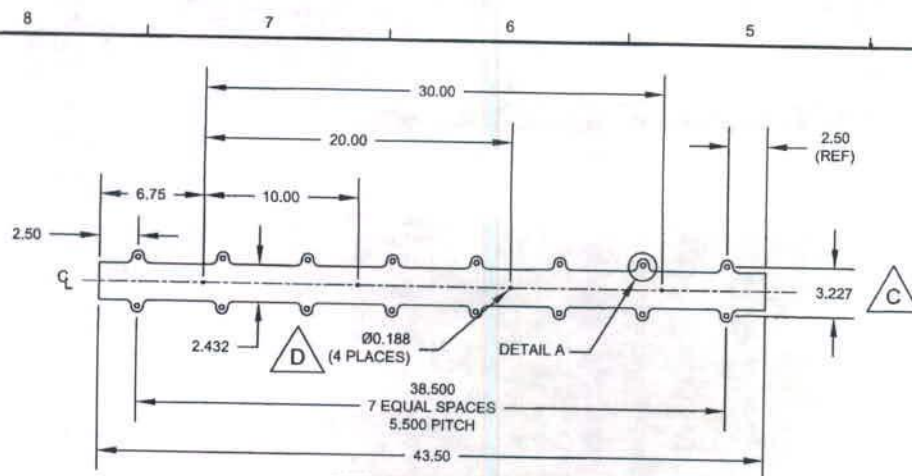
D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8, PG3 B5,C5: ADD D3564-15; PG1 B6,B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ON PG1; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5,7,B2: RELOCATE DETAILS AND SECTION; PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE	C8	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	CB		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	07.08.21		
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3564 TITLE WEARSHOE REV. D SHEET 1 OF 3 SCALE 1:8 COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

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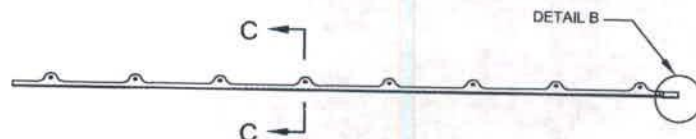
07.09.04



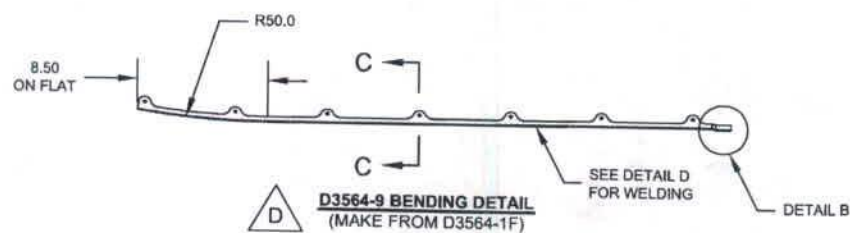




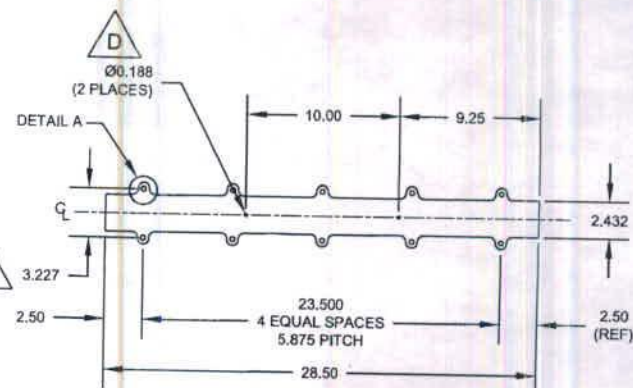
**D3564-5F FLAT PATTERN**



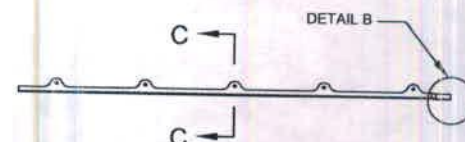
**D3564-5 BENDING DETAIL**  
(MAKE D3564-5 FROM D3564-5F)



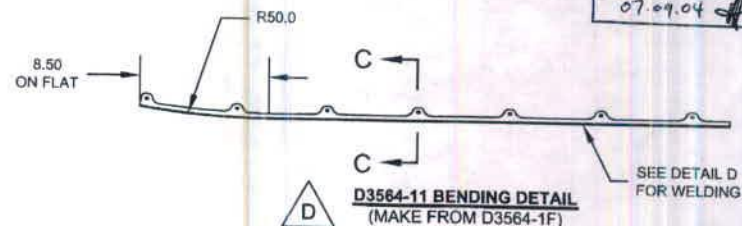
**D3564-9 BENDING DETAIL**  
(MAKE FROM D3564-1F)



**D3564-7F FLAT PATTERN**



**D3564-7 BENDING DETAIL**  
(MAKE D3564-7 FROM D3564-7F)



**D3564-11 BENDING DETAIL**  
(MAKE FROM D3564-1F)

RELEASED

07.09.04

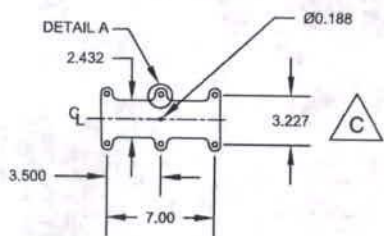
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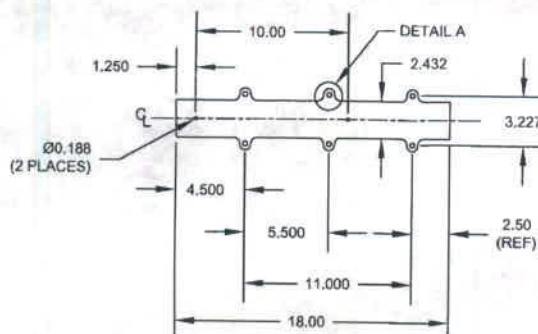




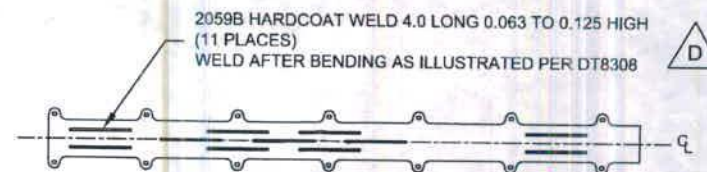
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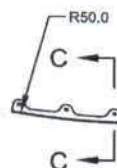
**D3564-13F FLAT PATTERN**



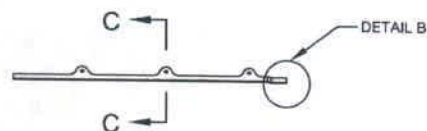
**D3564-15F FLAT PATTERN**



**DETAIL D**  
(D3564-1/-3/-9/-11 WELDING DETAIL)

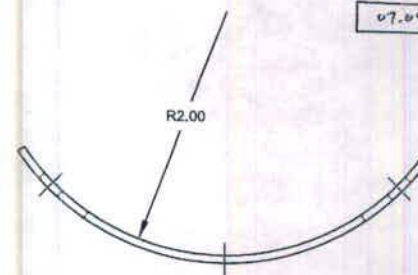


**D3564-13 BENDING DETAIL**  
(MAKE D3564-13 FROM D3564-13F)

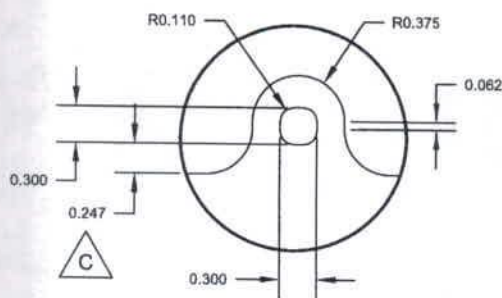


**D3564-15 BENDING DETAIL**  
(MAKE D3564-15 FROM D3564-15F)

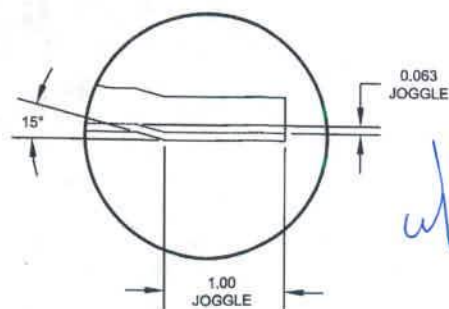
**RELEASED**  
07.09.04



**SECTION C-C**  
SCALE 1:1



**DETAIL A**  
SCALE 1:1



**DETAIL B**  
SCALE 1:1

*WLB 56533*

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CHECKED	PH	DRAWING NO.	REV. D
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8 7 6 5 4 3 2 1

